Dart Aerospace Ltd.

Date: Wednesday, 9/12/2007 12:16:31 PM
User: Kim Johnston

Process Sheet

Customer	: CU-DAR001 Dart Helicopters Services	**Drawing Name**	: HANDLE WELDMENT
Job Number	: 34636		
Estimate Number	: 12050		
P.O. Number	: N/A	**Part Number**	: D3355047
This Issue	: 9/12/2007 **S.O. No.** : N/A	**Drawing Number**	: D3355 REV B
Prsht Rev.	: NC	**Project Number**	: N/A
First Issue	: N/A **Type** : LARGE FAB ASSY	**Drawing Revision**	: B
Previous Run	: 30720	**Material**	: N/A
Written By	:	**Due Date**	: 9/21/2007 **Qty:** 4 **Um:** Each
Checked & Approved By	: 07.09.12		
Comment	: est rev A 06.01.20 new issue EC		

Additional Product

Job Number:

Seq. #:	Machine Or Operation:	Description :
1.0	D33555	medium tubing

Comment: Qty.: 1.0000 Each(s)/Unit Total : 4.0000 Each(s)
pick:

Qty	Part number	Description	Batch
1	D3355-5	medium tubing	B34646 * 07.09.19

(4)

Seq. #:	Machine Or Operation:	Description :
2.0	D33557	small tubing

Comment: Qty.: 1.0000 Each(s)/Unit Total : 4.0000 Each(s)
pick:

Qty	Part number	Description	Batch
1	D3355-7	small tubing	B34647 ✓ 07.09.19

(4)

Seq. #:	Machine Or Operation:	Description :
3.0	LARGE FAB 1	LARGE FABRICATION RESOURCE 1

Comment: LARGE FABRICATION RESOURCE 1
Weld assembly as per dwg
07.09.19 (4)

Seq. #:	Machine Or Operation:	Description :
4.0	QC9	VISUAL WELDING INSPECTION

Comment: VISUAL WELDING INSPECTION 07/09/19 (4)

Seq. #:	Machine Or Operation:	Description :
5.0	QC5	INSPECT WORK TO CURRENT STEP

Comment: INSPECT WORK TO CURRENT STEP 07/09/19 (✓4)

Form: process

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: ____________ **PAR #:** ______ **Fault Category:** ____________ **NCR:** Yes (No) **DQA:** LD **Date:** 07/01/21

QA: N/C Closed: _____ **Date:** _________

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Wednesday, 9/12/2007 12:16:31 PM
User: Kim Johnston

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services
Drawing Name: HANDLE WELDMENT

Job Number: 34636
Part Number: D3355047

Job Number:

Seq. #:	Machine Or Operation:	Description :
6.0	POWDER COATING	POWDER COATING

m/8052

Comment: POWDER COATING
Powder Coat Fire Red (Ref: 4.3.5.10) as per QSI 005 4.3 FX 01/09/20 (4)

Seq. #:	Machine Or Operation:	Description :
7.0	QC3	INSPECT POWDER COAT/CHEMICAL CONVERSION

Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION (4)

Seq. #:	Machine Or Operation:	Description :
8.0	PACKAGING 1	PACKAGING RESOURCE #1

Comment: PACKAGING RESOURCE #1
Identify and Stock
Location:_______ CAL (4)

Seq. #:	Machine Or Operation:	Description :
9.0	QC21	FINAL INSPECTION/W/O RELEASE

(4)

Comment: FINAL INSPECTION/W/O RELEASE 07/09/21

Job Completion

W 07-09-21

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: ____________________ **PAR #:** _______ **Fault Category:** _________________ **NCR:** Yes No **DQA:** _____ **Date:** _________

QA: N/C Closed: _____ **Date:** _________

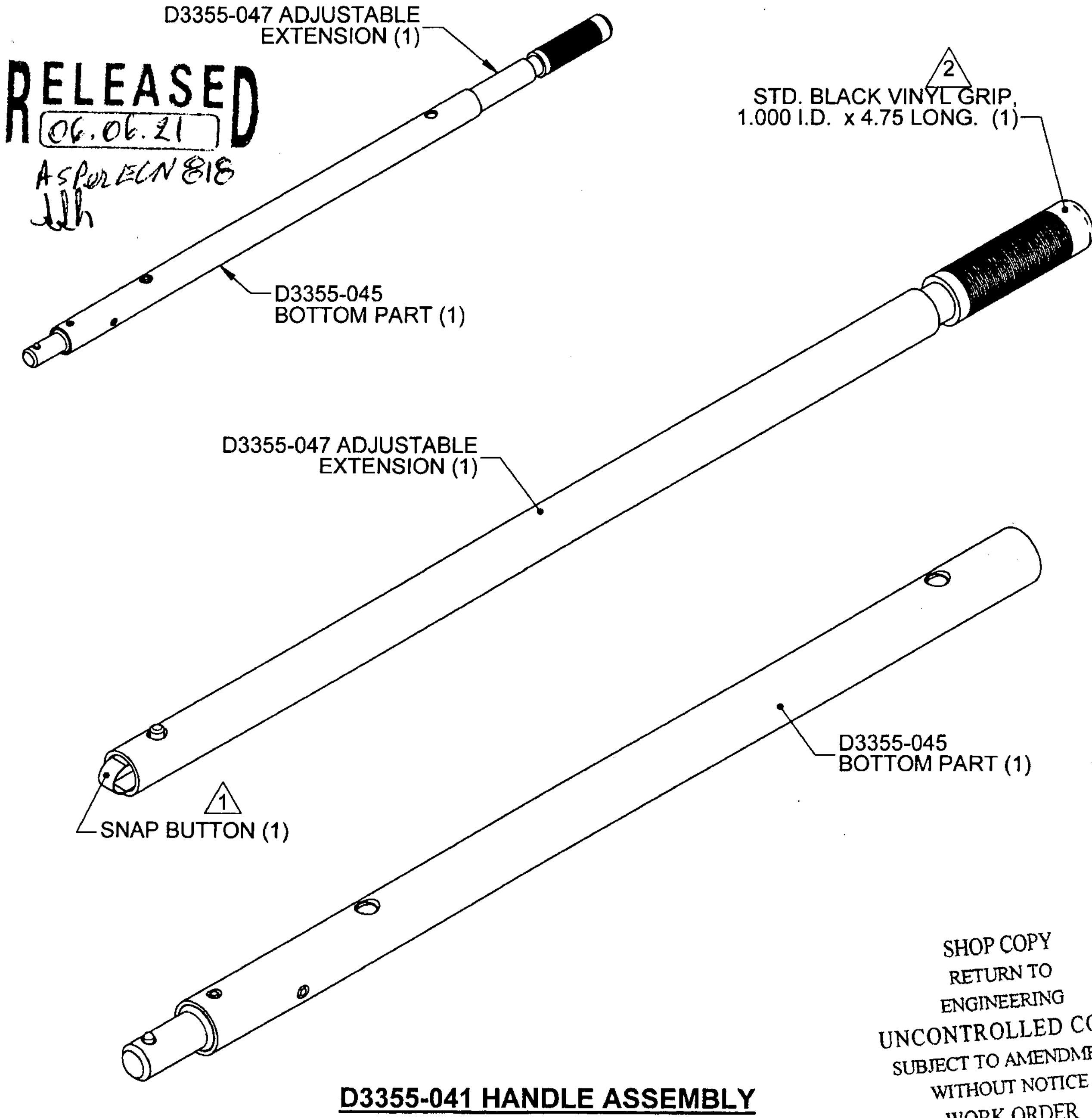
NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
			Corrective Action Section B					
DATE	STEP	Description of NC Section A	Initial Chief Eng	Action Description Chief Eng	Sign & Date	Verification Section C	Approval Chief Eng	Approval QC Inspector

NOTE: Date & initial all entries

DART

DESIGN	DRAWN BY	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA
RF	CB	
CHECKED	APPROVED	DRAWING NO. D3355 — REV. B — SHEET 1 OF 6
DATE 06.05.31		TITLE HANDLE WELDMENT — SCALE 1:8

A	05.02.07	NEW ISSUE
B	06.05.31	EDITED NOTE 1 (SHEET 2), UPDATE DETAIL B



D3355-041 HANDLE ASSEMBLY

SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 34636

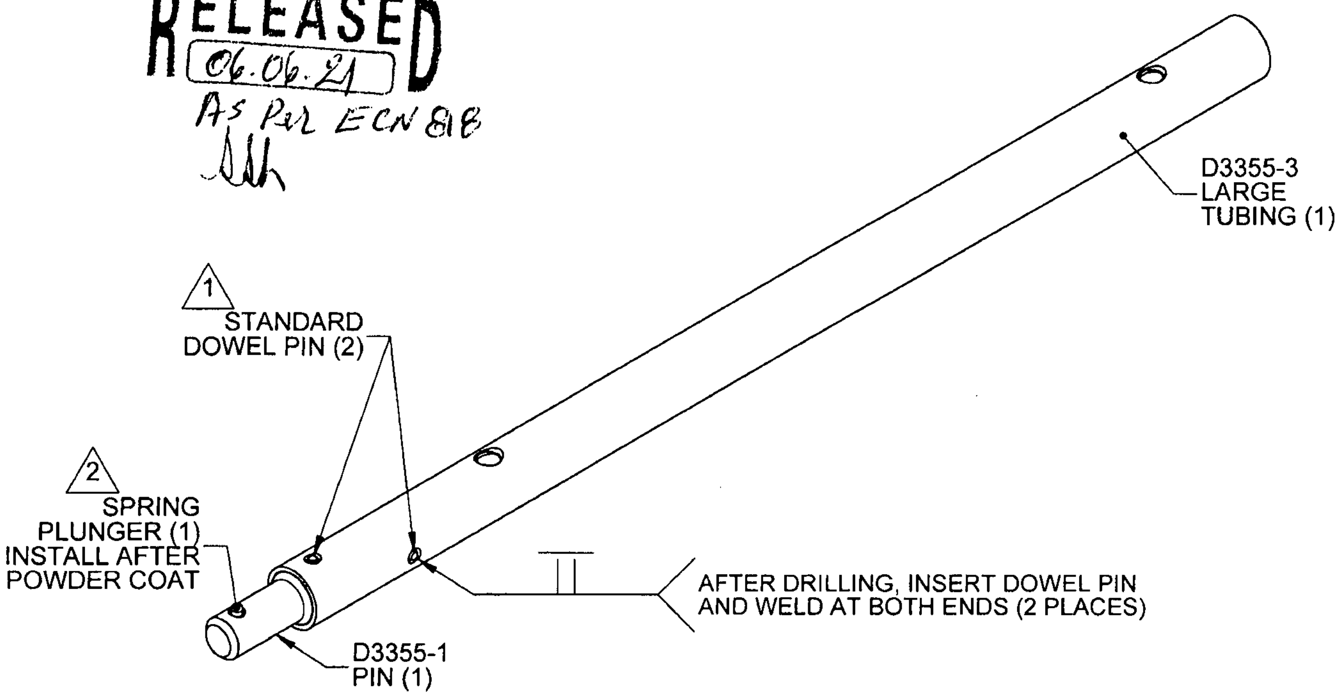
NOTES:

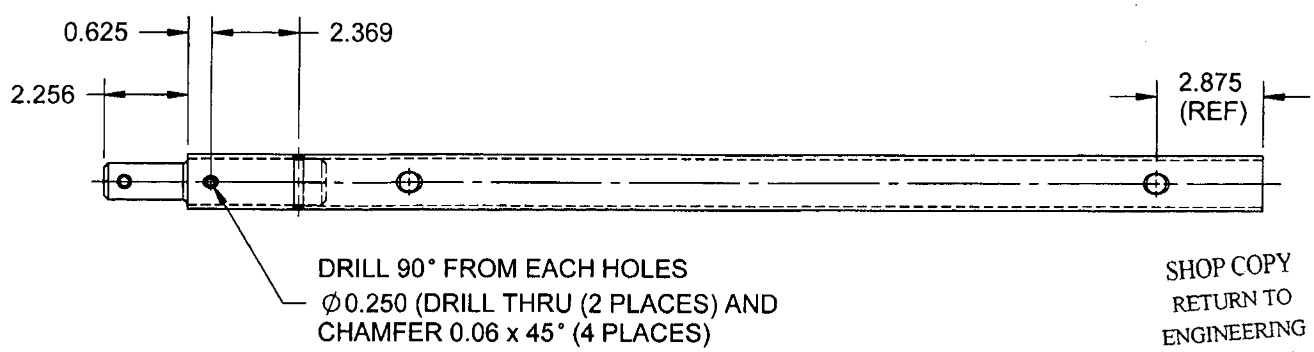
1) POSSIBLE SUPPLIER: REID TOOLS SUPPLY CO. P/N VA-2160
2) POSSIBLE SUPPLIER: REID TOOLS SUPPLY CO. P/N GP-1R

DESIGN RF	DRAWN BY CB	**DART AEROSPACE LTD** HAWKESBURY, ONTARIO, CANADA
CHECKED	APPROVED	DRAWING NO. D3355 — REV. B — SHEET 2 OF 6
DATE 06.05.31		TITLE HANDLE WELDMENT — SCALE 1:5

DART

RELEASED 06.06.21
As Per ECN 818





SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
B NO. 34636

D3355-045 BOTTOM PART

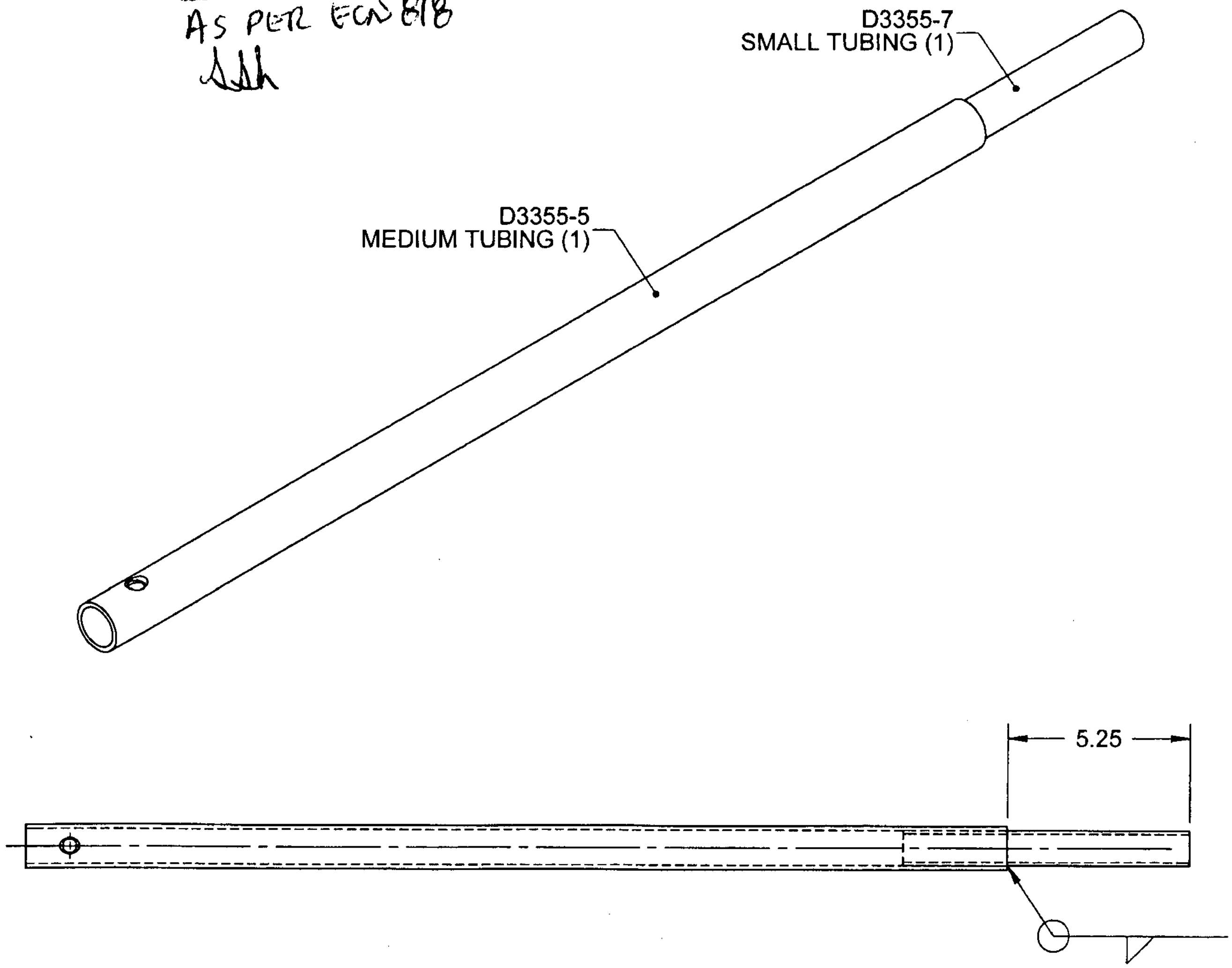
NOTES:

1) STEEL STANDARD GROUND DOWEL PIN, ∅0.250 X 1.50 LONG
   POSSIBLE SUPPLIER: SPAENAUR, P/N 238-043
2) SPRING PLUNGER, POSSIBLE SUPPLIER: REID TOOLS SUPPLY CO. P/N VA-7130
3) WELD PER DART QSI 004
4) FINISH: POWDER COAT PAINT FIRE RED (4.3.5.10) PER DART QSI 005 4.5
5) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
6) ALL DIMENSIONS ARE IN INCHES
7) BREAK ALL SHARP EDGES 0.010 TO 0.020

DESIGN RF	DRAWN BY CB	**DART AEROSPACE LTD** HAWKESBURY, ONTARIO, CANADA	
CHECKED	APPROVED	DRAWING NO. D3355	REV. B SHEET 3 OF 6
DATE	06.05.31	TITLE HANDLE WELDMENT	SCALE 1:5

DART

RELEASED 06.06.21
AS PER ECN 818



D3355-047 ADJUSTABLE EXTENSION

SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 34636

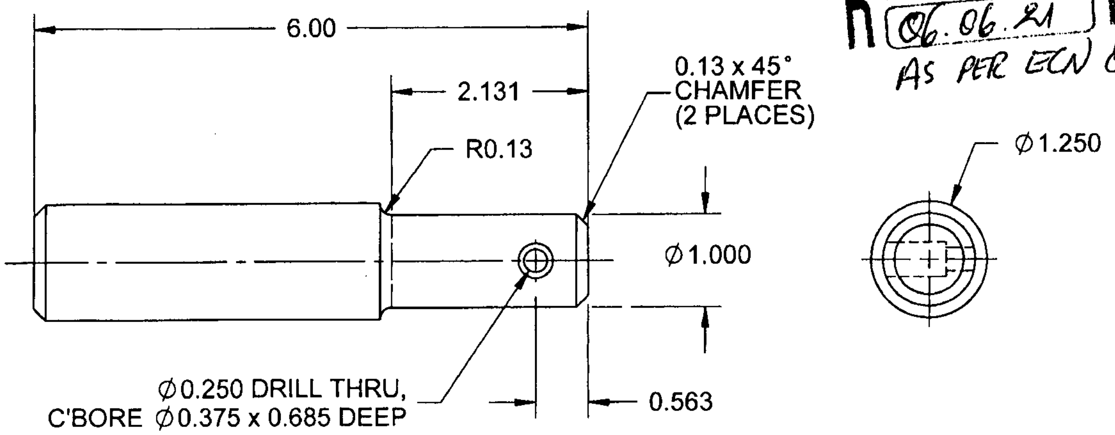
NOTES:

1) WELD PER DART QSI 004
2) FINISH: POWDER COAT PAINT FIRE RED (4.3.5.10) PER DART QSI 005 4.5
3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
4) ALL DIMENSIONS ARE IN INCHES
5) BREAK ALL SHARP EDGES 0.010 TO 0.020

DART

DESIGN RF	DRAWN BY CB	**DART AEROSPACE LTD** HAWKESBURY, ONTARIO, CANADA	
CHECKED	APPROVED	DRAWING NO. D3355	REV. B SHEET 4 OF 6
DATE 06.05.31		TITLE HANDLE WELDMENT	SCALE 1:2

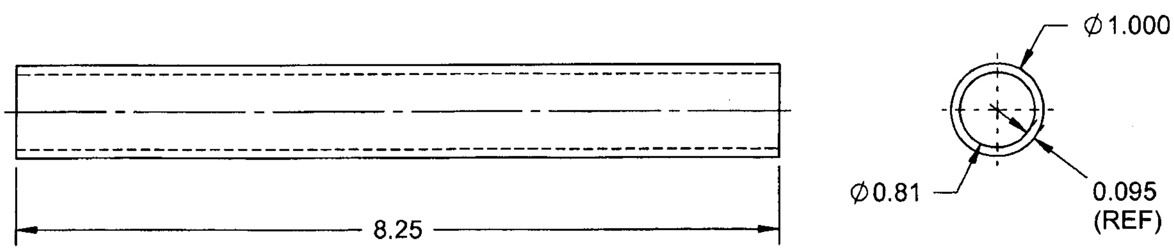
RELEASED 06.06.21 AS PER ECN 818



D3355-1 PIN

D3355-1 NOTES:

1) MATERIAL: AISI-4130/ AISI-4140 OR ASTM A304-02/ A-434-BC/ A193-03 - GRADE-B7/ A29-03/ A322-91 OR UNS#-G41400 ROUND BAR, (REF. DART SPEC. M4140H-R)
2) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
3) ALL DIMENSIONS ARE IN INCHES
4) BREAK ALL SHARP EDGES 0.010 TO 0.020



D3355-7 SMALL TUBING

D3355-7 NOTES:

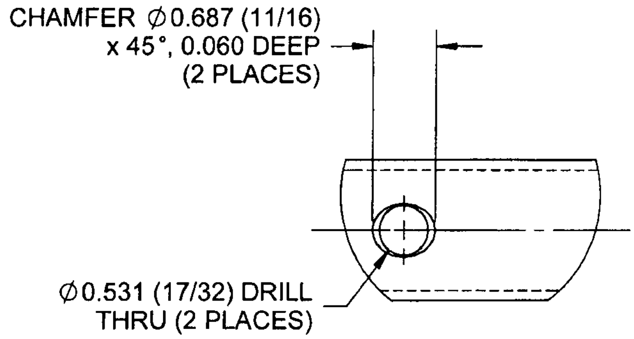
1) MATERIAL: AISI 1018-1025 MILD STEEL SEAMLESS ROUND TUBING (REF. DART SPEC. M1020TR1.000W.095)
2) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
3) ALL DIMENSIONS ARE IN INCHES
4) BREAK ALL SHARP EDGES 0.005 TO 0.010

SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 34636

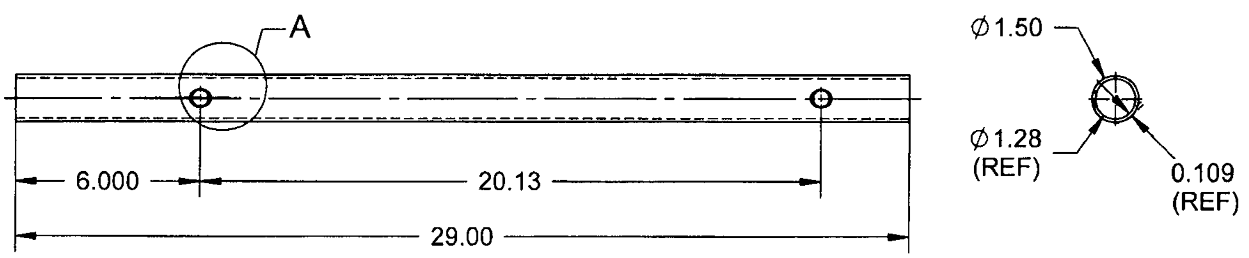
DESIGN RF	DRAWN BY CB	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED	APPROVED	DRAWING NO. D3355	REV. B SHEET 5 OF 6
DATE 06.05.31		TITLE HANDLE WELDMENT	SCALE 1:6

RELEASED 06.06.21

AS PER ECN 818



DETAIL A
SCALE 1 : 2



D3355-3 LARGE TUBING

NOTES:

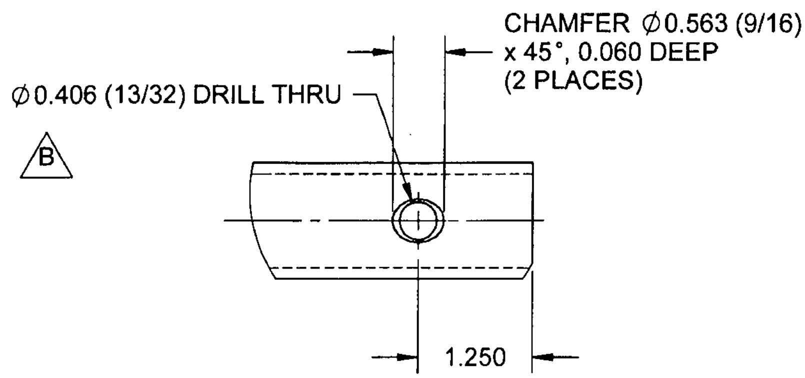
1) MATERIAL: AISI 1018-1025 MILD STEEL SEAMLESS ROUND TUBING
(REF. DART SPEC. M1020TR1.500W.109)
2) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
3) ALL DIMENSIONS ARE IN INCHES
4) BREAK ALL SHARP EDGES 0.015 TO 0.030

SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 34636

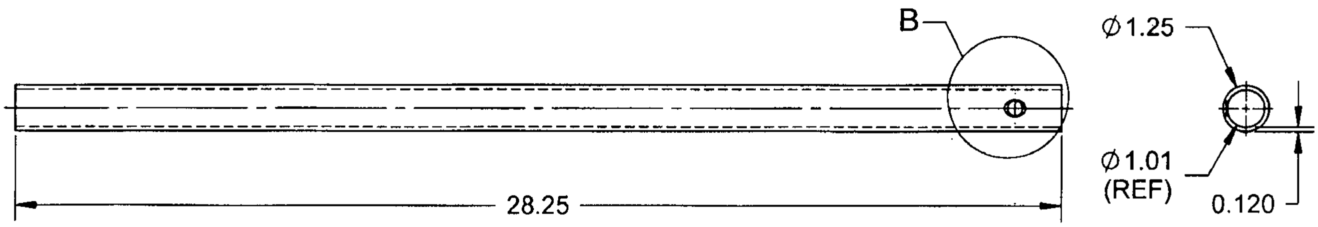
DESIGN	DRAWN BY	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA
RF	CB	
CHECKED	APPROVED	DRAWING NO. D3355 REV. B SHEET 6 OF 6
DATE 06.05.31		TITLE HANDLE WELDMENT SCALE 1:5

DART

RELEASED 06.06.21 AS PER ECN 818



DETAIL B
SCALE 1 : 2



D3355-5 MEDIUM TUBING

NOTES:

1) MATERIAL: AISI 1018-1025 MILD STEEL SEAMLESS ROUND TUBING
(REF. DART SPEC. M1018TR1.250W.120)
2) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
3) ALL DIMENSIONS ARE IN INCHES
4) BREAK ALL SHARP EDGES 0.015 TO 0.030

SHOP COPY RETURN TO ENGINEERING
UNCONTROLLED COPY SUBJECT TO AMENDMENT WITHOUT NOTICE
WORK ORDER NO. 34636